

Date: Wednesday, 6/14/2006 1:05:26 PM
 User: Linda LaCelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: INLET SCOOP
Job Number	: 27542		
Estimate Number	: 12421		
P.O. Number	: N/A	Part Number	: D34789
This Issue	: 6/14/2006 S.O. No. : N/A	Drawing Number	: D3478 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 6/16/2006
Checked & Approved By	: <u>SEE ABOVE USER.</u>	Qty:	10 Um: Each
Comment	: Est Rev:A New Issue 06-01-31 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 1302 For D3478-9S

Spin as per Dwg D3478

Possible Supplier: SIEG

Material release note is required

CZ 06/30/04

2.0	D34789S	INLET SCOOP, SPINNING DETAIL
-----	---------	------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 scoop outlet

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

CZ 06/14/04

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Scribe line at .180" Below center line of part

2-Rough Cut Part on Band Saw Leaving some Material.

FF 06.06.15


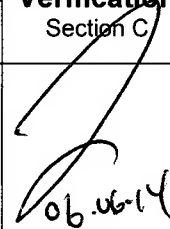

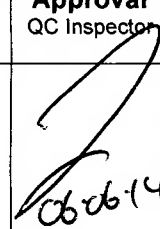
10

Proceed to Step 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/06/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		Parts are ^{.015} over over tol. on the 1.54 dim.		Acceptable		 06-06-14	 06-06-14	 06-06-14

NOTE: Date & initial all entries

Date: Wednesday, 6/14/2006 1:05:26 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET SCOOP

Job Number: 27542

Part Number: D34789

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Using DT8842 Angle Block, Sand Part on Disk Sander to Scribed line.

4-Deburr.

FF 06.06.15

10

6.0

QC5

INSPECT WORK TO CURRENT STEP



06.06.15

10

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 447

06/06/16 (10)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/16

06.06.16

06/06/14

Proceed to step 57

Job Completion



POSITIVE RECALL

EFFECTIVE 06.06.14

AUTH

RELEASED

DATE

06.06.15

~~POSITIVE RECALL~~

~~EFFECTIVE~~

~~AUTH~~

~~RELEASED~~

~~DATE~~

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

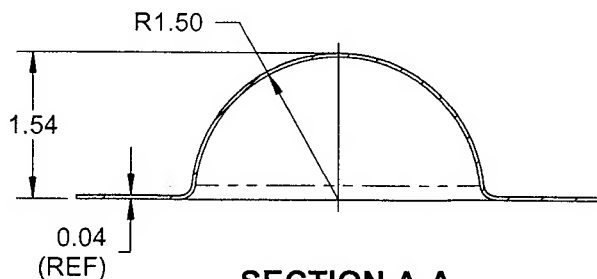
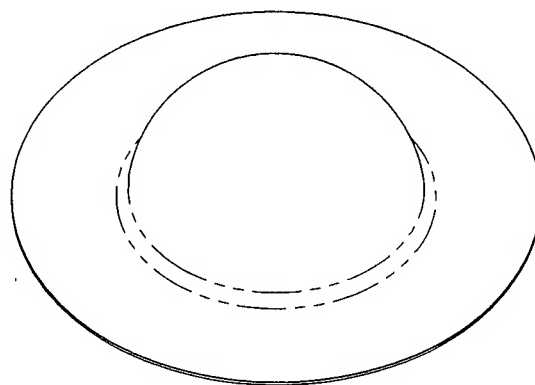
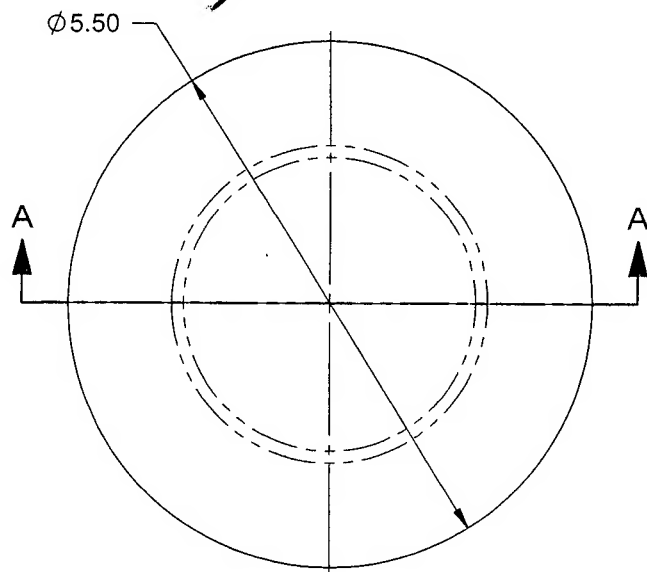
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3478	REV. B SHEET 6 OF 7
DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

RELEASED

REFERENCE ONLY



SECTION A-A

D3478-9S AIR INLET SCOOP, SPINNING DETAIL

NOTES:

- 1) MATERIAL: 2024-0 ALUMINUM SHEET, 0.040" THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T0S.040)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

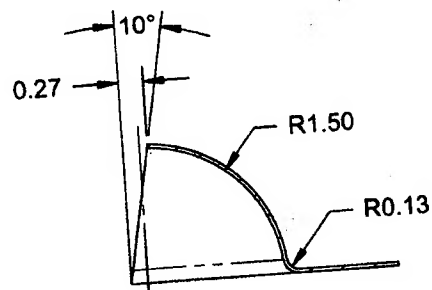
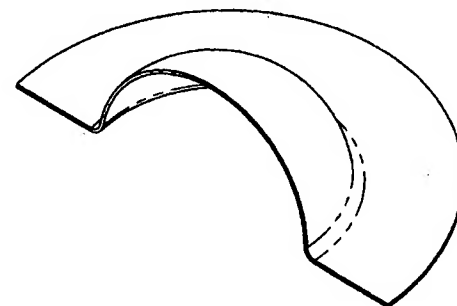
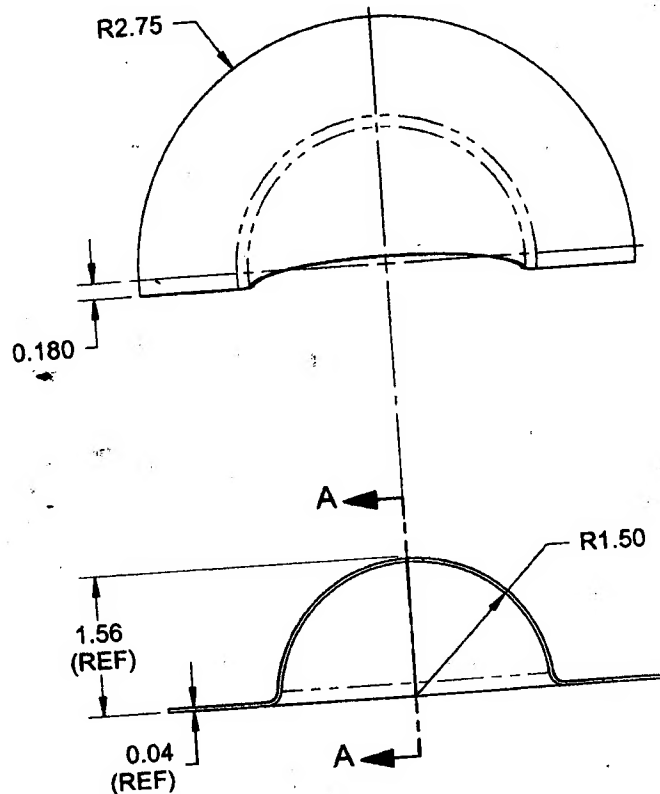
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3478	REV. B SHEET 7 OF 7
DATE 06.05.16		TITLE AIR INLET ADAPTER	SCALE 1:2

RELEASED
06.05.16



SECTION A-A

D3478-9 INLET SCOOP

REFERENCE ONLY

NOTES:

- 1) MATERIAL: MAKE FROM D3478-9S
- 2) IDENTIFY WITH DART P/N D3478-9 USING FINE POINT PERMANENT INK MARKER
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CUSTOMER 02510		SHIP DATE 02/17/06 SHP		GROSS WEIGHT 211		QUOTE 38-259436-1		OF 1		PACKING LIST																																					
BILL TO SIEGS MANUFACTURING LTD.		WORK ORDER **		ORDER DATE 02/03/06 ORD		DELIVERY DATE 02/17/06 DEL		SHIP BRANCH 38(17)		TEST RESULTS																																					
SIEGS MANUFACTURING LTD. 6236 - 205 STREET LANGLEY BC CANADA V2Y 1N7		01		19044 95A AVENUE, SURREY BRITISH COLUMBIA, CANADA V4N		Copper and Brass Sales Canada A ThyssenKrupp Materials NA company		ThyssenKrupp		WORK ORDER UY2370																																					
CUSTOMER P.O. NUMBER ARLA		TERRITORY 02		ENTRY ID 38JJJ		CUSTOMER SIGNATURE		DATE																																							
BUYER ARLA		INSIDE SALES JOE J. DILIELLO		INVENTORY		26.78 LB		27.00																																							
BUYER TELEPHONE (604) 530-7455		INSIDE SALES TELEPHONE (604) 882-3493 223		BILLING		1.00 PC		1.00																																							
INTERNAL		COMPLETE X		PARTIAL		CANCEL		WAREHOUSE																																							
TO CUSTOMER OUR TRUCK/PRT-BESTWAY-JA81		FOR ORIG		PACKED WITH OTHER GOODS		FINISHED GOODS LOCATION		WARN LABEL:1005																																							
BILL OF LADING		FREIGHT STATUS PPD		75260																																											
<p>AIRCRAFT QUALITY 2024-O CLAD ALUM SHEET, .040 X 48 X 144 -SIEGS MANUFACTURING LTD. ***, NO PROCESSING - 48" X 144" Mill Dimensions., PVC Clear 1 Side. Test Results Attn to: QA Department. , **ok to ship as per P Walsh **all sheets, must be squared and flat on each skid-please ensure each skid has 2 X 4 , legs cut and placed on bottom of skid (along 48" width) for easy forklift , access. **each size to be sep. on indiv.</p>																																															
<table border="1"> <tr> <td colspan="2">FULL</td> <td colspan="2">SCRAP</td> <td colspan="2">FILED BY USA</td> <td colspan="2">PACKED BY</td> <td colspan="2">QA AUDIT</td> <td colspan="2"></td> </tr> <tr> <td colspan="4">CUSTOMER RECEIVING HOURS 7-3:30pm, avoid 11:3</td> <td colspan="2">MAX SKID WEIGHT 3000</td> <td colspan="2">LOADING INSTRUCTIONS FORK</td> <td colspan="2">MAXIMUM SKID WEIGHT 3000</td> <td colspan="2"></td> </tr> <tr> <td>BOXES</td> <td>UNITS</td> <td>CASES</td> <td>CUSH</td> <td>PKGS</td> <td>SKIDS</td> <td>1</td> <td>SOLE</td> <td>TUBES</td> <td>CTNS</td> <td>FLAT</td> <td>COILS</td> </tr> </table>												FULL		SCRAP		FILED BY USA		PACKED BY		QA AUDIT				CUSTOMER RECEIVING HOURS 7-3:30pm, avoid 11:3				MAX SKID WEIGHT 3000		LOADING INSTRUCTIONS FORK		MAXIMUM SKID WEIGHT 3000				BOXES	UNITS	CASES	CUSH	PKGS	SKIDS	1	SOLE	TUBES	CTNS	FLAT	COILS
FULL		SCRAP		FILED BY USA		PACKED BY		QA AUDIT																																							
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BOXES	UNITS	CASES	CUSH	PKGS	SKIDS	1	SOLE	TUBES	CTNS	FLAT	COILS																																				

TEST RESULTS -----

CERTIFICATE OF COMPLIANCE

We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products.
The products we distribute are not hazardous in their received state. For MSDS sheets go to www.copperandbrass.com/msds
or call 246-233-9682. We hereby certify that the material above complies with the following specifications:

QQ-A-250/5*

AMS 4040

ASTM-B209

TAC NO QUANTITY UOM VENDOR VEND PO HEAT/LOT
1.00 PC ALCOA I 08G6265 533531

PCS 1 TAC NO

QUANTITY UOM VENDOR VEND PO HEAT/LOT

PCS

Dant.

613-632-1053 4 Pages

ATTN: Gerry

604-530-7490

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material meet the composition, heat and the mechanical properties shown on the face of this sheet.

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

205131 Ship Date	9050 B.L. No.	Invoice No.	Alcoa No. Item
2003-01-10	26546	56912	DS-56734-1
P.O. No./Govt Contract No.		Customer	
8G6265		C&B-WALLINGFORD	

Page 1

Ship To: COPPER & BRASS SALES INC
WALLINGFORD BRANCH
5 STERLING DRIVE
WALLINGFORD, CT 06492

Item Description
.040 IN TH (+.0000 -.003) X 48 IN W X 144
IN LN (N) A/T ALCLAD 2024-G FLAT SHEET MILL FINISH (PART 752603-
1) RAWMA 02-182-030. PER(EXC GA TOL) AMS-QQ-A-
250/5 REV A & EXCEPT MARKING
ASTM209 REV 02 & EXCEPT MARKING AMS4040 REV M
(MARKED)) INTERLEAVED MAX GROSS
SKID WGT: 2400 LB QUAN TOL +/-30 %
CQR 0137587 REV 01 QRR 000879 CUST REQ 02-12-
15 *** W/R 02-12-21 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	639714	533531	2035	77	PC	
2	639810	533531	795	30	PC	
3	639812	533531	2011	77	PC	
4	639813	533531	2115	81	PC	
5	639814	533531	2039	77	PC	
			8995	342		

Notes for CQR: 0137587.1

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/5 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/5F, AMENDMENT 2.
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/5F, AMENDMENT 2 ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/5.

CQR: 0137587.1 -Specification Limits

Temp	Dir		UTS KSI	TYS KSI	EL4D PCT
0	Long Transv.	Max	30.0	14.0	
		Min			12
Temp	Dir		UTS KSI	TYS KSI	EL4D PCT
T42	Long Transv.	Max			
		Min	57.0	34.0	15
Temp	Dir		UTS KSI	TYS KSI	EL4D PCT
T42P	Long Transv.	Max			
		Min	57.0	34.0	15



SIKORSKY

003
003/004

Sieg's Mfg. Ltd.

06/15/2006 12:13 FAX 6045307490
06/15/2006 THU 10:36 FAX

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

Page 2

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

205131

Ship Date

2003-01-10

P.O. No./Govt Contract No.

866265

9050

B.L. No.

24546

Invoice No.

56912

Customer

C&B-WALLINGFORD

Alcoa No. Item

DS-56734-1

CQR: 0137587.1 -Specification Limits (cont.)

Temp	Dir	UTS KSI	TYS KSI	EL4D PCT
T62	Long Transv.	Max		
		Min	60.0	47.0

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other	Each	Total	Aluminum
Alloy 2024	Max	.50	.50	4.9	.9	1.8	.10	.25	.15	.05	.15	
	Min			3.8	.30	1.2						REMAIN

Chemical Composition	SI+FE	CU	MN	MG	V	ZN	TI	Other	Each	Aluminum
LYNBR	Max	.70	.10	.05	.05	.10	.03	.03		
Alloy 1230	Min									99.30

Lot: 5J3531 -Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No. Test	UTS KSI	TYS KSI	EL4D PCT
0	Long Transv.	2	Max	23.4	11.5
			Min	23.4	11.4

Temp	Dir	No. Test	UTS KSI	TYS KSI	EL4D PCT
T42	Long Transv.	2	Max	60.8	37.6
			Min	60.5	37.5

Temp	Dir	No. Test	UTS KSI	TYS KSI	EL4D PCT
T42P	Long Transv.	2	Max	62.5	38.4
			Min	62.4	38.2

Temp	Dir	No. Test	UTS KSI	TYS KSI	EL4D PCT
T62	Long Transv.	2	Max	61.8	49.4
			Min	61.6	48.9

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

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P.O. No./Govt Contract No.

8G6265

9050

B.L. No.

24546

Invoice No.

56912

Customer

C&B-WALLINGFORD

Alcoa No. Item

OS-56734-1

Page 3

Lot: 533531 - Mechanical, Physical, Metallography, Quantometer Results (cont.) -----
Cast Number Chemical SI FE CU MN MG CR ZN TI
H9532015 Actuals .07 .17 4.6 .64 1.6 .01 .10 .03